

Date: Monday, 06/11/2006 9:20:30 AM  
User: Linda Lacelle

# Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D412-664-203
Job Number : 29275	
Estimate Number : 10804	
P.O. Number : <i>N/A</i>	Part Number : D412664203
This Issue : 06/11/2006 S.O. No. : <i>N/A</i>	Drawing Number : NCR 095
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : <i>N/A</i> Type : LANDING GEAR	Drawing Revision : <i>N/A</i>
Previous Run : 29190	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 13/11/2006 Qty: 1 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment :	

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

TRANSPORT CANADA APPROVAL # 09-39		CHG		CHG003
PAN	D412-664-203	STC	SH01-9	
DESC	Crosstube Aft High	STC	SR01298NY	
LOT	B27391	STC		
MODEL	Bell 412	STC		

1.0

PACKAGING 1

PACKAGING RESOU



Comment: PACKAGING RESOURCE #1  
REMOVE FROM STOCK  
D412-664-203  
RECORD B/N'S

B27391

*[Signature]* 06-10-27

2.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1  
REMOVE SUPPORT D2896-1  
FROM CROSSTUBES AND LABEL SUPPORT  
WITH B/N OF CROSSTUBE IT CAME OFF OF

PT 06-11-01 ①

3.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1  
REMOVE CENTRE ABRASION STRIP  
AND CLEAN OFF ALL ADHESIVE RESIDUE

PT 06-11-01 ①

Date: Monday, 06/11/2006 9:20:30 AM  
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## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D412-664-203

Job Number: 29275

Part Number: D412664203

Job Number:



Seq. #: Machine Or Operation: Description :

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*06-11-01* ①

5.0 SPRAY PAINTING SPRAY PAINTING



Comment: SPRAY PAINTING  
RE-PAINT SECTION OF CROSSTUBE  
BETWEEN THE TWO CHAFING SHIELDS  
AS PER QSI 005

*06-11-13* ①

6.0 QC14 Inspect Spray Paint



Comment: Inspect Spray Paint

*06-11-14* ①

7.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1  
INSTALL SUPPORT D2896-1  
USING MAGNOBOND 6398 B *M102437*  
ENSURING B/N MATCHES CROSSTUBE  
AS PER DSI 9357  
REPLACE CLAMPS  
2 X MS21920-30 B *M101568*  
ADD RUBBER CUSHION  
2 X D2182B (D2182B058) B *296042*

*06-11-20* ①

8.0 MS2192030 clamp(per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
clamp(per MIL-DTL-8783C)

*101568*

9.0 D2182B Neoprene Cushion-.750 bl



Comment: Qty.: 0.9600 f(s)/Unit Total : 0.9600 f(s)  
Neoprene Cushion-.750 bl

*28042*

Date: Monday, 06/11/2006 9:20:31 AM  
User: Linda Lacelle

## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D412-664-203

Job Number: 29275

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*06-11-21* (1)

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

*06-11-21* (1)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
REPACKAGE PER PPP

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*06-11-21* (1)

Job Completion



*06-11-21*



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9357	REV. A SHEET 1 OF 2
DATE 06.10.25		TITLE CROSSTUBE SUPPORT CHANGE	SCALE NTS
A	06.10.25	NEW ISSUE	

## **DART SERVICE INSTRUCTION**

TO AMEND INSTALLATION INSTRUCTIONS IIN-D212-664 Rev. C AND  
INSTRUCTIONS FOR CONTINUOUS AIRWORTHINESS ICA-D212-664 Rev. 2  
REF. CANADIAN STC: SH01-9  
REF. FAA STC: SR01298NY

For D412-664-203 Aft Crosstubes at CHG 002 or later, the D2856-600-1087 Abrasion Strip has been removed, the center D2896-1 Support has been bonded onto the crosstubes using Magnobond 6398 and D2182B058 Rubber Cushions have been installed underneath the MS21920-30 Clamps. Amend Parts List of IIN-D212-664 Section 5 and ICA-D212-664 Section 32.8 as follows:

### Remove:

Item	QTY -203	Part Number	Description
32	1	D2856-600-1087	ABRASION STRIP

### Add:

Item	QTY -203	Part Number	Description
41	2	D2182B058	RUBBER CUSHION

To prevent the center support from shifting on D412-664-203 Crosstubes at CHG 001, the D2896-1 Support should be removed and re-installed as follows:

- 1) Follow section 32.1 of ICA-D212-664 for the removal of the crosstubes from the helicopter.
- 2) Remove the qty(2) MS21920-30 Clamps from the crosstube that fasten the D2896-1 Supports to the crosstube.
- 3) Remove the D2856-600-1087 Abrasion Strip from the crosstube per section 32.5 of ICA-D212-664.
- 4) Inspect the crosstube surface underneath the support for corrosion and mechanical damage per items 5.3.1 and 5.3.2 of the 300 hour inspection. Repair damage within acceptable limits per item 5.3.3 of the 300 hour inspection. Touch up finish per item 5.3.9 of 300 hour inspection.
- 5) Apply a 0.03" to 0.06" thick layer of Magnobond 6398 underneath D2896-1 Support and re-install the Support on the crosstube as shown in Figure 1. Use rocker beam assembly to properly align the D2896-1 Support. Ensure the Rocker Beam Assembly can move freely without any friction with other parts. Install a D2182B058 Rubber Cushion on each MS21920-30 Clamp. Position and secure the D2896-1 Support on the crosstube using MS21920-30 Clamps. Torque clamps 80-100 in-lb. Let the D412-664-203 Crosstube Assembly cure before re-installing the crosstube or the aircraft.
- 6) Re-install the D412-664-203 crosstube per section 32.2.5 through 32.2.9 of ICA-D212-664.

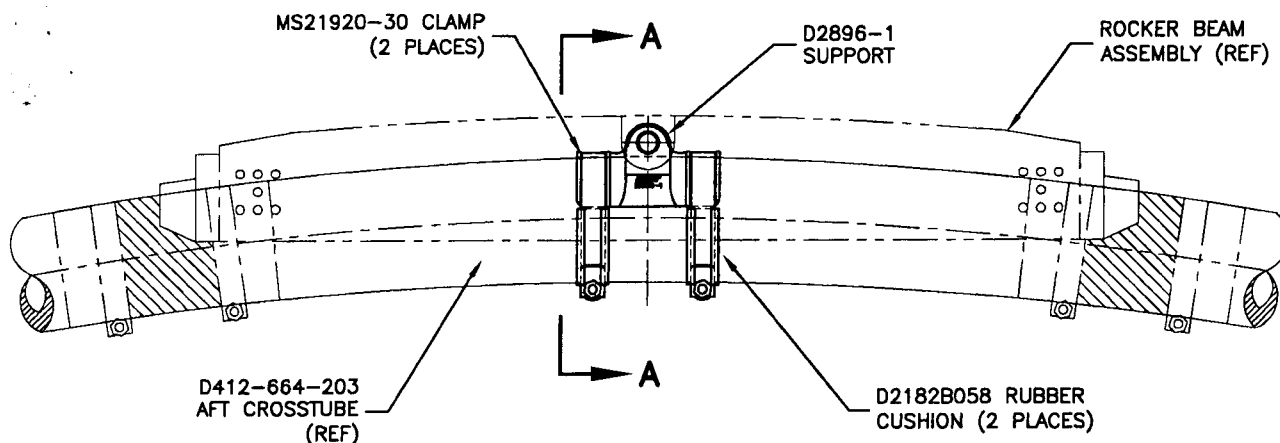
CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
<b>APPROVED</b>	
BY: <i>[Signature]</i>	D. SHEPHERD (DE # 02)
DATE: 06.10.25	
CERT. NO.: SH01-9	
ISSUE: 3	

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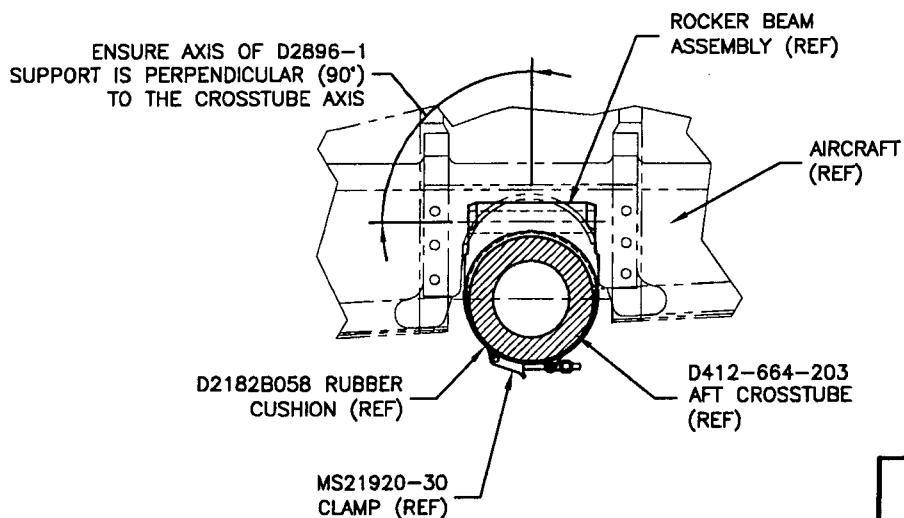
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9357	REV. A SHEET 2 OF 2
DATE 06.10.25		TITLE CROSSTUBE SUPPORT CHANGE	SCALE NTS



**FIGURE 1 - CROSSTUBE SUPPORT  
INSTALLATION ON D412-664-203**



**SECTION A-A**  
AIRCRAFT BODY SHOWN  
AS REFERENCE

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

**APPROVED**

BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 06.10.25  
CERT. NO.: SH01-9  
ISSUE: 3

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